



OWNER'S MANUAL

JWP-12DX 12-1/2" Deluxe Wood Planer



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M-708521 03/01

Important Information

2-YEAR LIMITED WARRANTY

**JET offers a two-year limited
warranty on this product**

REPLACEMENT PARTS

Replacement parts for this tool are available directly from JET Equipment & Tools.
To place an order, call 1-800-274-6848. Please have the following information ready:

1. Visa, MasterCard, or Discover Card number
2. Expiration date
3. Part number listed within this manual
4. Shipping address other than a Post Office box.

REPLACEMENT PART WARRANTY

JET Equipment & Tools makes every effort to assure that parts meet high quality and durability standards and warrants to the original retail consumer/purchaser of our parts that each such part(s) to be free from defects in materials and workmanship for a period of thirty (30) days from the date of purchase.

PROOF OF PURCHASE

Please retain your dated sales receipt as proof of purchase to validate the warranty period.

LIMITED TOOL AND EQUIPMENT WARRANTY

JET makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follows: 2 YEAR LIMITED WARRANTY ON THIS JET PRODUCT. Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities or to a lack of maintenance. JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD SPECIFIED ABOVE FROM THE DATE THE PRODUCT WAS PURCHASED AT RETAIL. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MECHANABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY OR FOR INCIDENTAL, CONTINGENT, SPECIAL OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU. To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an authorized service station designated by our Auburn office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, JET will either repair or replace the product or refund the purchase price, if we cannot readily and quickly provide a repair or replacement, if you are willing to accept such refund. JET will return repaired product or replacement at JET's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of JET's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights, and you have other rights, which vary, from state to state.

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WARNING

For your own safety, read this instruction manual before operating the planer.

Always wear eye protection.

Do not wear gloves, necktie, or loose clothing.

Do not force work through the machine. Allow the planer to apply the proper feed rate.

Check the feed rollers before use for chips and sawdust lodged between any of the components. If the rollers are not seated firmly, the feed rollers will not hold stock firmly against the bed and the chance of kickback increases.

Plane only wood boards with no loose knots and few tight knots as possible.

Never stand directly in line with either the infeed or outfeed ends. Always stand off to one side of the machine.

Be sure the workpiece is free of nails, screws, stones, and other foreign objects which could damage the knives.

Be certain the knives are properly attached to the cutterhead as described in the instructions.

Allow the cutterhead to reach full speed before feeding the workpiece.

- **KEEP GUARDS IN PLACE** and in working order.
- **REMOVE ADJUSTING KEYS AND WRENCHES.** Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
- **KEEP THE WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- **DO NOT USE IN A DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
- **KEEP CHILDREN AWAY.** All visitors should be kept safe distance from the work area.
- **MAKE THE WORKSHOP KID PROOF** with padlocks, master switches, or by removing starter keys.
- **DON'T FORCE THE TOOL.** It will do the job better and safer at the rate for which it was designed.
- **USE THE RIGHT TOOL.** Don't force a tool or attachment to do a job for which it was not designed.
- **USE THE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersize cord will cause a drop in the line voltage resulting in loss of power and overheating. **For runs up to 25 feet, use a 18 AWG or larger gauge cord. For runs up to 50 feet, use a 16 AWG or larger gauge cord. For runs up to 100 feet, use a 14 AWG or larger gauge cord. For runs up to 150 feet, use a 12 AWG or larger gauge cord. Runs over 150 feet are not recommended.** If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.
- **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.

- **ALWAYS USE SAFETY GLASSES.** Also use face or dust masks if the cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- **SECURE WORK.** Use clamps or a vise to hold the work when it's practical. It's safer than using your hand and it frees both hands to operate the tool.
- **DON'T OVERREACH.** Keep proper footing and balance at all times.
- **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- **DISCONNECT TOOLS** before servicing; when changing accessories, such as blades, bits cutters, and the like.
- **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure the switch is in the off position before plugging in the machine.
- **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause a risk of injury.
- **NEVER STAND ON A TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
- **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
- **NEVER LEAVE THE TOOL RUNNING UNATTENDED. TURN THE POWER OFF.** Don't leave the tool until it comes to a complete stop.
- **SOME DUST CREATED** by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint
 - Crystalline silica from bricks and cement and other masonry products, and
 - Arsenic and chromium from chemically treated lumber.
- **YOUR RISK FROM** those exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles
- **DO NOT OPERATE TOOL** while under the influence of drugs, alcohol or any medication.

Grounding Instructions

Caution: This tool must be grounded while in use to prevent electric shock.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

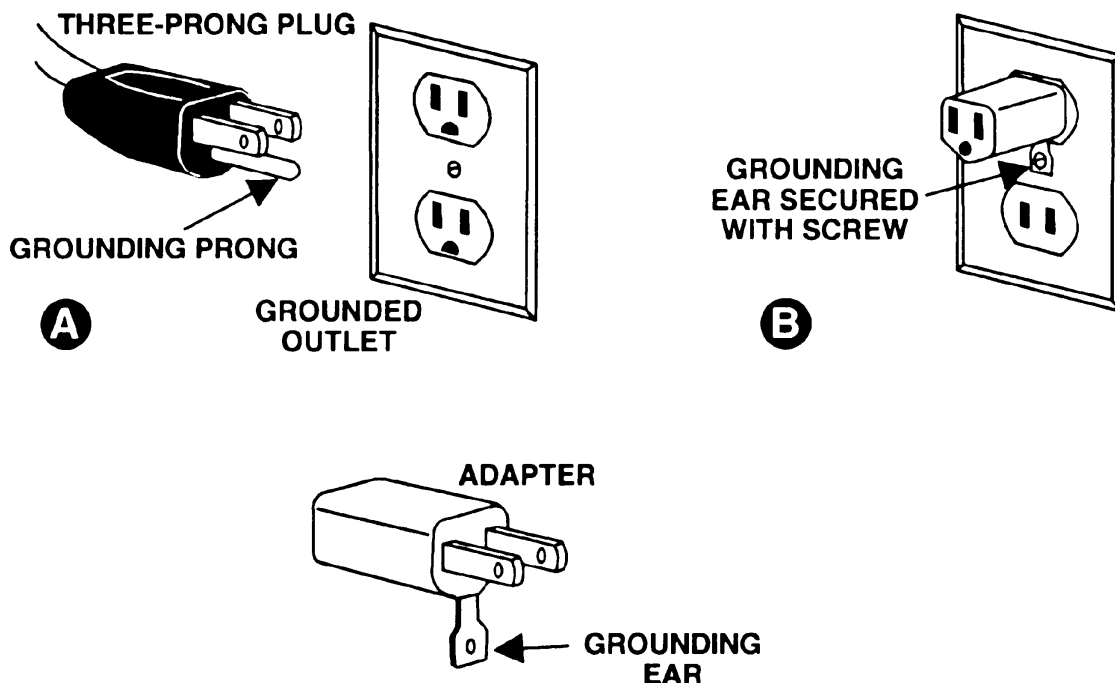
Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor, with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only three wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug.*

Repair or replace a damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Figure A below. The tool has a grounding plug that looks like the grounding plug as illustrated in Figure A below. A temporary adapter, which looks like the adapter as illustrated in Figure B below, may be used to connect this plug to a two-pole receptacle, as shown in Figure B if a properly grounded outlet is not available.** The temporary adapter should only be used until a properly grounded outlet can be installed by a qualified electrician. The green colored rigid ear or tab, extending from the adapter, must be connected to a permanent ground such as a properly grounded outlet box.



* Canadian electrical codes require extension cords to be certified SJT type or better.

** Use of an adapter in Canada is not acceptable.

Specifications:

JWP-12DX

Stock Number.....	708521
Cutting Capacity	
Length of Unbutted Stock	13" (min.)
Width of Stock.....	12-1/2"
Thickness of Stock	3/16" to 6"
Depth of Cut.....	1/8" on 5-1/2" Wide Board
.....	1/16" on 12" Wide Board
Feed Speed (FPM)	26
Number of Knives.....	2
Knife Size	12.5" long x 1/8" thick x 3/4" tip to tip
Cutterhead Diameter	1-7/8"
No Load Cutterhead Speed (RPM)	8,000
Cuts per Minute	16,000
Motor	2 HP, 115V, 16 AMP
Overall Dimensions	22"L x 14-1/2"W x 15-1/2"H
Net Weight (approx.)	60-1/2 lbs.
Shipping Weight (approx.)	64-1/2 lbs.

Introduction

The JET JWP-12DX planer you have purchased is a high quality tool that will give you years of superior service. You will get maximum performance and enjoyment from your new planer if you will take a few moments now to review the entire manual before beginning assembly and operation.

The JET JWP-12DX, as well as all JET products, are backed by a nationwide network of authorized distributors and/or service centers. Please contact your nearest distributor should you require parts or service. Parts are also available directly from JET by calling 1-800-274-6848.

Now that you have purchased a planer, it is a good time to consider a dust collection system. See your local JET distributor for the complete line of dust collectors and the full line of JET Dust Collector Hoses and Accessories. Customize your installation and obtain maximum performance with JET's dust hoods, hoses, clamps, fittings, and blast gates.

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The specifications in this manual are given as general information and are not binding. JET Equipment and Tools reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.



WARNING

Read and understand the entire contents of this manual before attempting assembly or operation!

Failure to comply may cause serious injury!

Contents of the Shipping Container

- 1 Planer
- 1 Chip Deflector
- 1 Accessory Package:
 - 1 Handle Assembly
 - 1 Knife Setting Gauge
 - 4 8mm x 50 Hex Socket Cap Screws
 - 1 6mm x 16 Hex Socket Cap Screw
 - 1 6mm Lock Washer
- 1 Owner's Manual
- 1 Warranty Card

Tools Included for Assembly and Adjustment

- 1 8/10mm Box Wrench
- 1 Cross Point/Flat Blade Combination Screwdriver
- 1 4mm Hex Wrench
- 1 5mm Hex Wrench
- 1 6mm Hex Wrench

Optional Accessories Available:

708500: Dust Hood with 4" Hose Adapter

708523: Stand

708813: Double Edged Knives

Assembly

1. Remove any packing material from in and around the planer.
2. Attach the handle assembly (A, Fig. 1) to the planer with one 6mm x 16 hex socket cap screw (B, Fig. 1) and one 6mm lock washer.
3. Lower the head assembly by using the handwheel assembly.
4. Insert the chip deflector (A, Fig. 2) into position and fasten to the upper frame assembly with two M5 x 30mm screws (B, Fig. 2) and two M5 lock washers.
5. Tighten both screws firmly with a hex wrench.

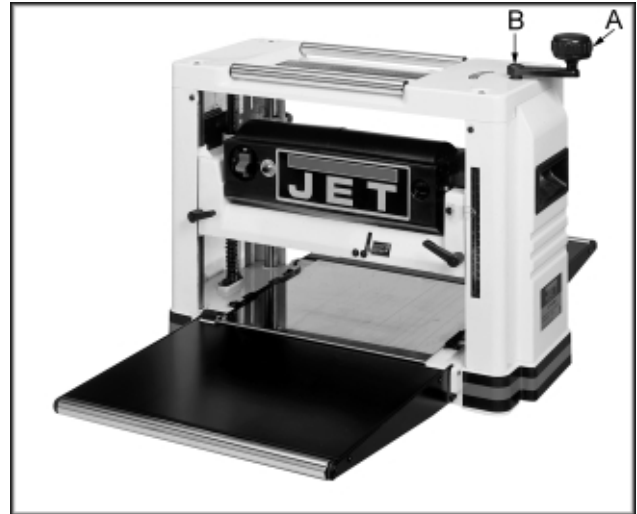


Fig. 1

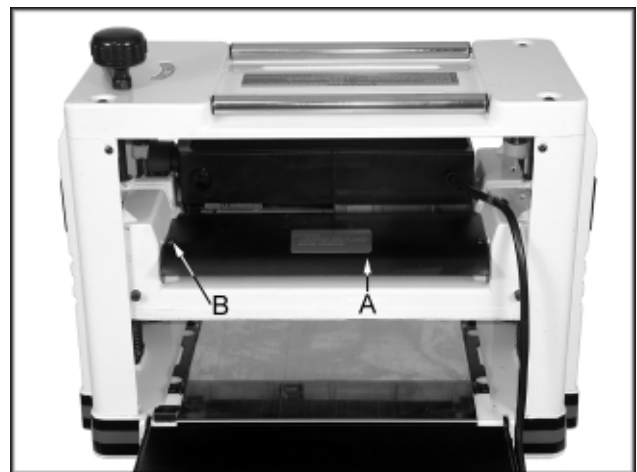


Fig. 2

Leveling the Extension Tables

1. The extensions were leveled with the table at the factory. If adjustment is necessary follow these steps:
2. Raise the cutterhead assembly by turning the handwheel.
3. Place a straight edge (A, Fig. 3) across both extension table rollers.
4. Loosen lock nuts (C, Fig. 4) and adjust bolts (B, Fig. 4) until the extension table rollers are level with the table.
5. The bolts should be adjusted equally so that the extension table rollers are level from side to side.

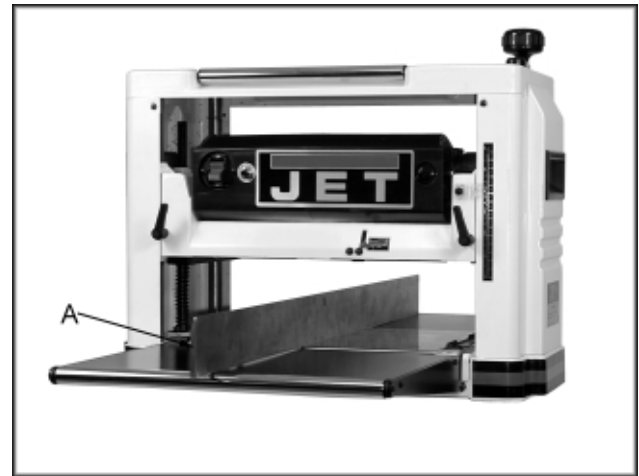


Fig. 3

Attaching the Planer to a Workbench or Stand



CAUTION

It is highly recommended the planer be used with the optional stand (JET part #708523) or mounted to a sturdy base. Failure to comply may cause the planer to tip over during operation.

Follow these instructions if the planer is **not** going to be used with the optional JET stand. If you purchased a JET stand (708523) follow those instructions now.

1. Measure and mark location for holes to be drilled as per the diagram in Figure 4.
2. Drill four holes with a 3/8" drill bit.
3. Move the planer into position over the holes.
4. Attach the planer to the workbench with four M8-1.25 x 50L hex socket cap screws. **Note:** The M8 x 50mm screws provided might be too long, or two short for your specific application. Make sure the bolts tighten snugly before operating the planer.

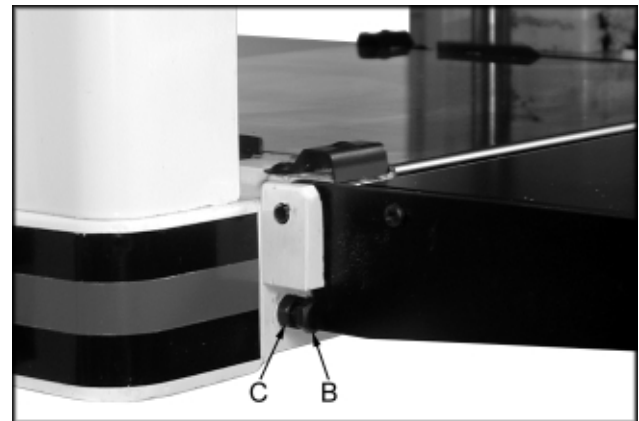


Fig. 4

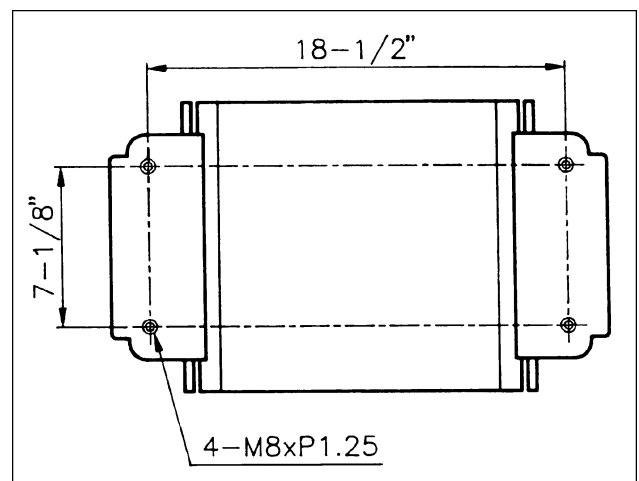


Fig. 5

OPERATION

Danger Zone: Be aware of the danger zone, the area directly in front of and to the back of the planer when it is in operation. Never stand in this area while stock is being planed. Always stand to one side, or the other to avoid injury should kickback occur.

Safety Switch

WARNING

Always make sure the switch is in the off position before plugging in the planer! Failure to comply may cause serious injury!

To remove the safety switch, first turn off the planer. Pull out the switch key (A, Fig. 6), and store in a safe place. Re-install the switch key just before operating the planer.

Setting the Depth of Cut

CAUTION

Never turn the thickness adjustment handle while stock is being planed. This can put stress on the blades, the cutterhead, and the motor which can lead to machine damage.

1. One side of the material should be run through a jointer before planing.
2. Turn off the planer.
3. Place the material with the flat side down on the planer bed. Slide the material under the infeed roller and lower the head until the gauge (A, Fig. 7) shows $1/64$ ".
4. Run the material through the planer at this setting to start.
5. One full clockwise revolution of the handle assembly (B, Fig. 6) will lower the depth of cut approximately $5/64$ ".
6. First cuts should be very shallow. You may wish to make several passes shallower than $5/64$ ".

Planing Warped Wood

WARNING

Do not attempt to plane a board which is warped along its length. A warped board can jam itself against the cutterhead knives resulting in kickback and or damage to the planer.

Failure to comply may cause serious injury!

For best results one side of the material should be run through a jointer prior to planing. However, if a board is somewhat cupped, as in Figure 8, you may attempt to plane it. If the

board is narrow enough, consider using a tablesaw or bandsaw to rip the top of the warp before planing the board. If this is not practical, plane the top of the board until it is flush with the two sides of the board.

Turn the board over and plane the bottom edges until they are flush with the middle. After planing the board, use a tablesaw or jointer to square the board's edges.

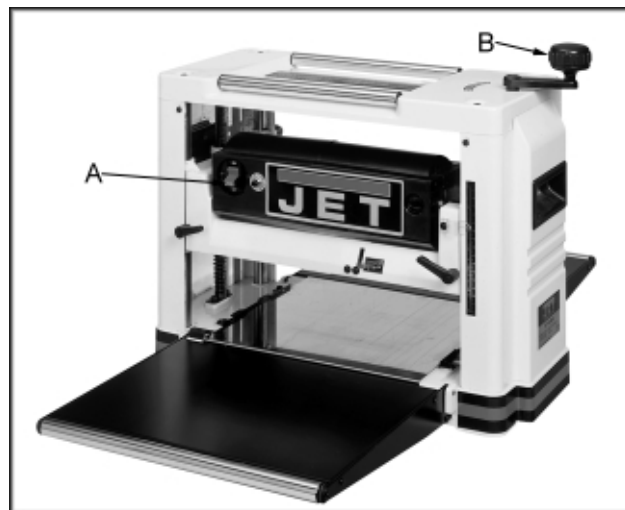


Fig. 6



Fig. 7

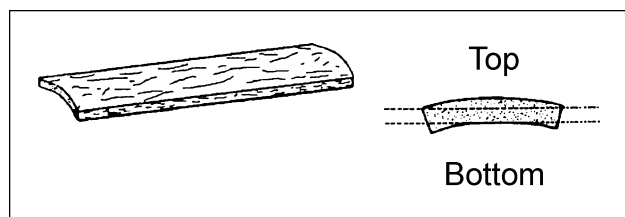


Fig. 8

Grain Direction

Always feed the board so the knives are cutting in the same direction as the wood grain, as shown in Figure 9. If you cut against the grain, the wood may “chip out” leaving an undesirable finish.

Knots and Trouble Spots

Wood with knots, and “wild” grain is always difficult to surface and requires extra care. Check that any knots are solid. Do not plane stock with loose knots. Take light cuts. Be especially cautious of kickbacks and stop cutting immediately if the board will not feed smoothly.

Snipe

Use the head locks (A, Fig. 10) during the finishing passes to reduce snipe. These are friction locks only, and will still allow you to raise or lower the head, however, you should always loosen locks prior to raising or lowering the head. If the end of the stock is allowed to “droop” when it is fed into or coming out of the planer, the knives may cut a large snipe (gouge) at the beginning or end of the board. If the snipe is deep, be more careful how the board is supported. Keep it parallel to and flat on the table at all times. Use a support roller and/or support stand for extra support at both the infeed and outfeed ends of the planer. If snipe cannot be avoided cut the material longer than needed and trim the ends.

Ridges

Damaged or nicked knives leave long ridges along the entire length of a board.



WARNING

Never attempt to plane second-hand lumber, painted or varnished wood, plywood, or particle board. These materials will damage planer knives.

Failure to comply may cause serious injury!

Make sure to inspect each board before attempting to plane it. Do not attempt to plane second-hand lumber with nails below the surface, painted wood, plywood, hardboard, wood with a glue bead, or any other material other than solid wood.

Planing Rough Lumber



CAUTION

Make sure wood is properly dried before planing. Wet or “green” lumber may clog the machine and lead to damage.

Air dried wood should stand for at least a year per inch of thickness of the rough cut stock. The moisture content of air dried wood should be about 12% to 15%. Kiln dried woods should have a moisture content of approximately 10%. Wood to be used in fine furniture should have a moisture content of 7% to 8%.

Joint one edge of the rough cut lumber before planing. This allows you to determine the way the grain travels. Feed the board into the planer so the knives cut with the grain, see figure 9.

Measure the rough lumber at several locations to find the thickest part. As wood dries, its dimensions vary - including its thickness. Set the planer to take a very shallow cut on the highest, thickest part of the board. Continue to take very shallow cuts until you can determine whether there are any knots or unusual grain patterns.

After completing one side, inspect the other side for irregularities.

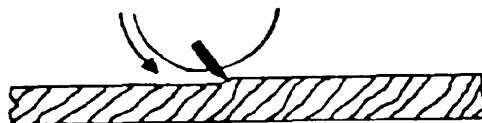


Fig. 9

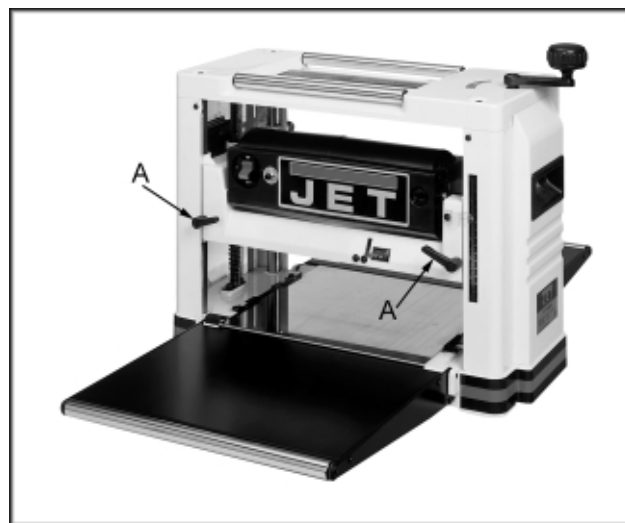


Fig. 10

Planing Glued-Up Boards

WARNING

Glued-up stock must dry for 24 hours before being planed!
Failure to comply may cause the stock to come apart in the planer leading to kickback which can cause serious injury!

The JWP-12DX planer is designed for planing solid wood. Other material, including glue, will dull or damage the knives. However, when you need to “true-up” glued-together stock, follow these suggestions.

As you glue the stock, scrub off all the glue on the surface with a wet rag. This prevents glue beads from forming on the wood surface. Allow the glue to dry at least 24 hours. Check the surface for any glue that you missed and remove with a scraper, chisel, or sander.

Set the cutterhead for a shallow depth of cut. When you are finished planing the glued-up board, unplug the planer and check both planer knives for built up pitch or other signs of wear.

Adjustments

The planer comes adjusted from the factory. If adjustment is necessary follow the steps listed.

Thickness Scale Pointer Adjustment

1. Place a board on the planer table.
2. Lower the cutterhead so that the planer knives are just above the board.
3. Plug in and turn on the planer.
 - If the planer knives touched the board, plane the board, and immediately turn off the planer. Do not move the cutterhead.
 - If the planer knives did not touch the board, very slowly lower the cutterhead until the planer knives touch the board. Plane the board and immediately turn off the planer.
4. Measure the thickness of the planed board. If the scale pointer (A, Fig. 11) does not match the thickness of the board, adjust the pointer with a screwdriver.

Cutterhead Parallel to Table Adjustment

WARNING

Planer blades are extremely sharp! Use caution when hands are around the cutterhead!
Failure to comply may cause serious injury!

The cutterhead has been adjusted parallel to the table at the factory. Use the following procedure to check and align the cutterhead parallel to the cutterhead:

1. **Disconnect the machine from the power source.**
2. Cut a hardwood block (B, Fig. 11) approximately 1" thick x 5" high x 4" wide. On one end, cut 45° bevels on all four sides.
3. Raise the cutterhead to the top.
4. If necessary, rotate the cutterhead so that both knives are pointing away from the table.
5. Place the gauge on the right side of the table, as shown in Figure 11.
6. Lower the cutterhead so that the cutterhead (not the planer knives) very lightly touches the top of the gauge.
7. Grasp the gauge near its bottom and carefully slide it along the table to the other side.

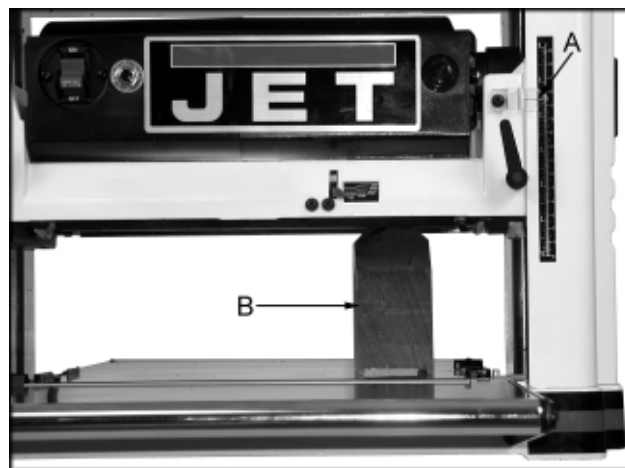


Fig. 11

The table and the cutterhead should be adjusted parallel at the factory. Only proceed with this adjustment if absolutely necessary.

1. Carefully turn the planer over to expose the bottom.
2. Remove the snap ring (A, Fig. 12).
3. Disengage the horizontal shaft gear (B, Fig. 12) from the vertical shaft gear (C, Fig. 12). **When disengaging the gears, do not rotate the horizontal shaft gear. This will disturb the alignment of the cutter and make the height scale inaccurate.**
 - If the left side of the cutterhead is higher than the right side, hand rotate the left vertical shaft gear clockwise in one gear tooth increments.
 - If the left side of the cutterhead is lower than the right side, hand rotate the left vertical shaft gear counter-clockwise in one gear tooth increments.
4. When parallel alignment between the cutterhead and table is reached, re-engage the gears and replace the snap ring.
5. Store the wood gauge for future use.

Removing and Installing Planer Knives



WARNING

Disconnect the planer from the power source before making any repair or adjustment!

Planer knives are extremely sharp! Handle with care to avoid injury!

Failure to comply may cause serious injury!



CAUTION

Both planer knives must be sharpened at the same time. Sharpening only one may throw the cutterhead out of balance and cause cutterhead ball bearing failure.

The cutterhead has two planer knives that will eventually need to be removed for sharpening, or replacement. **Note:** the knives are double edged so they can be rotated one time before needing to be sharpened. The blades should be sharpened at a 42° angle. To remove knives:

1. **Disconnect the machine from the power source.**

2. Lower the cutterhead as low as it will go.
3. Remove two hex socket cap screws (B, Fig. 13) and two lock washers holding the chip guard (A, Fig. 13) to the planer.
4. Set aside the chip guard.
5. Loosen seven screws (A, Fig. 14) and remove the first planer knife.
6. Loosen the second set of seven screws and remove the second knife.

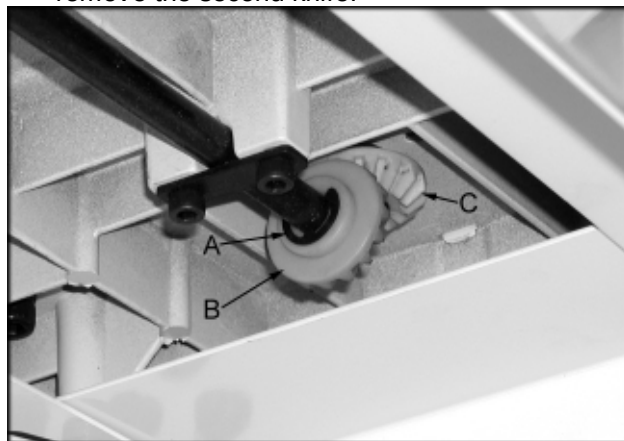


Fig. 12

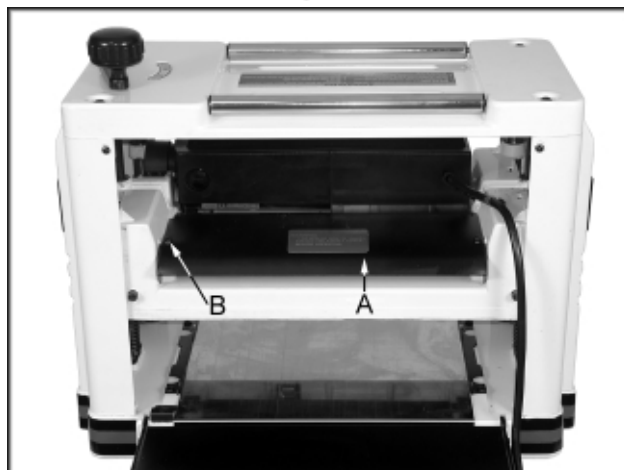


Fig. 13

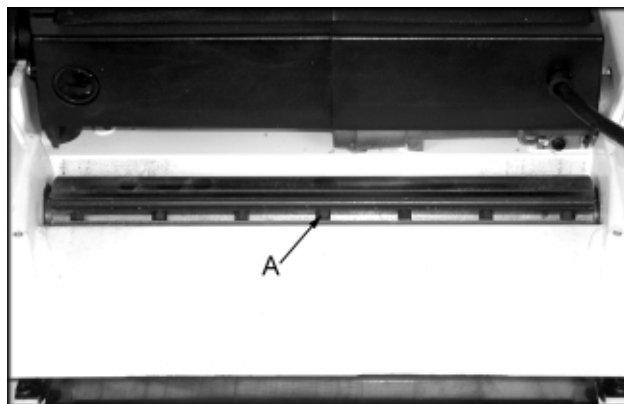


Fig. 14

To replace the knives:

Note: the knives are double edged so they can be rotated one time before needing to be sharpened.

1. Insert the first knife into the slot in the cutterhead. Make sure the sharpened edge is against the knife wedge (A, Fig. 15) and the ends of the knife are even with the ends of the cutterhead.
2. Place the knife gauge (B, Fig.15) at one end of the cutterhead (C, Fig. 15) and knife (D, Fig. 15). The edge of the knife must touch the gauge while the two feet of the gauge rest on the cutterhead.
3. Tighten the screw at this end of the knife.
4. Move the gauge to the other end of the cutterhead and check for proper knife depth.
5. Tighten the screw at this end of the knife.
6. Tighten remaining screws firmly, to a torque of 50 in. lbs. (See Fig. 14).
7. Rotate the cutterhead and install the second knife.
8. Install the chip guard.

Carbon Brush Maintenance

The JWP-12DX has two brushes that require periodic inspection and occasional replacement. If the motor is running properly, the brushes are good. If the motor slows down under a relatively light load, it is time for brush replacement:

1. **Unplug the machine from the power source.**
2. Remove the brush plugs (A, Fig. 16) with a screwdriver.
3. Gently pull out both brush holders. There is one on the opposite side of the motor
4. Inspect the brushes. If they are worn to the indicator line (A, Fig. 17) or they are defective, replace them.

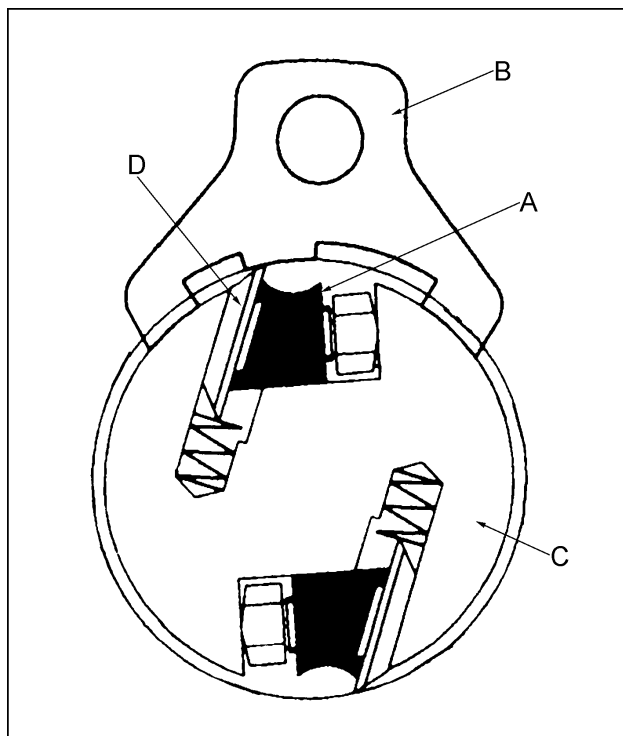


Fig. 15



Fig. 16

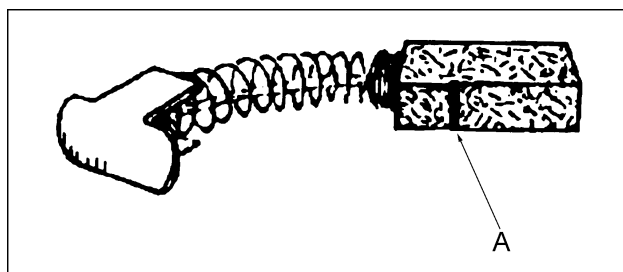


Fig. 17

Feed Roller Maintenance

The feed rollers are made of a rubber material and should be inspected after every hour of operation:

1. **Unplug the machine from the power source.**
2. Move the cutterhead to the top of the planer.
3. Inspect both the infeed and the outfeed rollers for sawdust and wood chips. Rotate the rollers by turning the cutterhead belt. Due to the gear reduction on the rollers the cutterhead must be rotated a significant amount. You can remove the right side panel to make the rotating of the cutterhead belt easier.
4. To remove sawdust or wood chips, first use a soft brush. If chips or dust remain, use a soft cloth with a mild cleaner. Do not touch the rollers with sharp or abrasive objects.

Lubrication



WARNING

Unplug the planer from the power source before attempting any lubrication!

Failure to comply may cause serious injury!

To access the following lubrication points, remove the elevating hand wheel assembly and the top and side cover assembly.

- **Leadscrews** - (B, Fig. 18) Apply a light coat of #2 lithium tube grease along the entire length of both leadscrews.
- **Columns** - (C, Fig. 18) Apply a light coat of #2 lithium tube grease to all four columns, upon which the cutterhead slides up and down. Wipe away excess grease.
- **Feed Rollers** - Carefully place the planer on its side and apply a drop of 30W machine tool oil to each of the four feed roller brackets (#33 in the head assembly breakdown). Wipe away any excess.
- **Drive Chain** - Apply a light coat of 30W machine tool oil to the drive chain. Keep the chain clean of dust, dirt, and wood shavings. Do not over lubricate. Over lubricating the chain will attract

contaminates and increase the wear on the chain.

To access the following lubrication points, carefully turn the planer over on its side.

- **Beveled Gears** - Apply a small dab of #2 lithium tube grease between the gears (#3 and #29 in the table assembly breakdown) on both the left and right side of the planer. Turn the height handle a few times to spread the grease and wipe off any excess.



Fig. 18

Maintenance



WARNING

All repairs, adjustments, and maintenance must be performed with the planer unplugged from the power source!

Failure to comply may cause serious injury!

Every one hour of running time	• Brush off and blow out all the sawdust and chips inside the planer. • Inspect the feed rollers (on either side of the cutterhead for any impacted wood chips. Wipe the rollers with a damp rag, and then dry.
Every five hours of running time	• Repeat the previous steps. • Clean pitch from the cutterhead. • Wax the cutterhead and table. • Inspect both planer knives. If needed, sharpen or replace. • Lubricate the two leadscrews and four columns.
Every 10 hours of running time	• Repeat the previous steps. Check knife positioning and knife mounting bolts. • Check both carbon brushes. Replace them, if necessary.
Every 50 hours of running time	• Repeat the previous steps. • Lubricate the height adjustment gears.

Troubleshooting

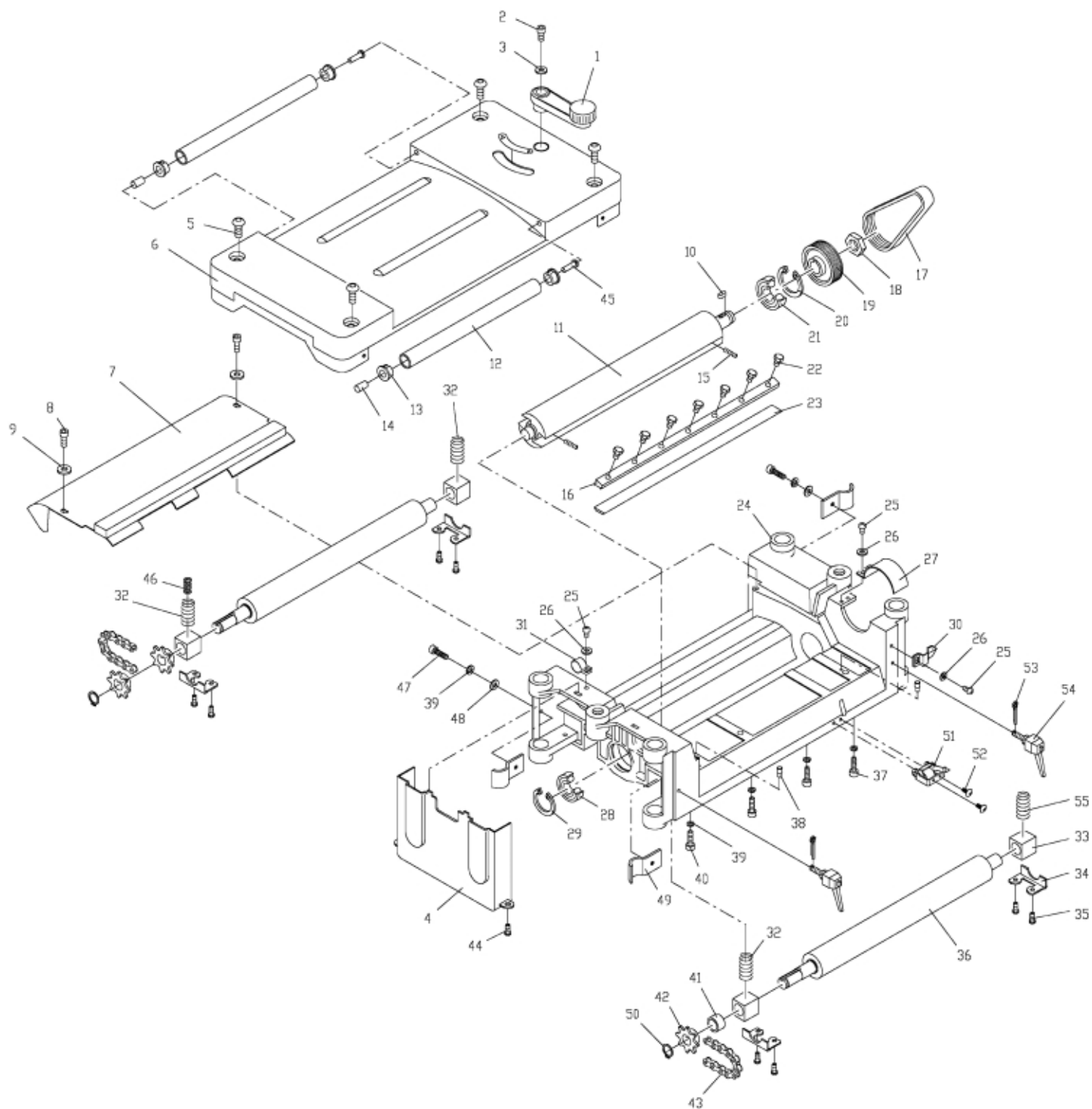
Problem

Possible Causes and Solutions:

Snipe	• Dull knives Sharpen knives • Inadequate support of long boards Support long boards with extension rollers
Fuzzy Grain	• Planing wood with high moisture content Remove moisture by drying or use dry wood • Dull knives Sharpen knives

Torn Grain	• Too heavy a cut Remove less material • Knives cutting against grain Cut with the grain • Dull knives Sharpen knives
Rough/Raised Grain	• Dull knives Sharpen knives • Too heavy a cut Remove less material while planing • Moisture content too high Remove moisture by drying or use dry wood
Poor Feeding of Lumber	• Motor belt slipping Replace motor belt • Planer bed rough or dirty Clean pitch and residue; wax planer bed • Surface of feed rollers are dirty Clean feed rollers with a cloth and mild cleaner
Uneven Depth of Cut Side to Side	• Cutterhead knife projection not uniform Adjust knives
Head Difficult to Adjust	• Lack of lubrication on corner posts and screws Lubricate corner posts and screws
Board Thickness Doesn't Match Depth Scale	• Depth scale incorrect Adjust depth scale
Machine Won't Start	• Not plugged in Check power source • Circuit breaker/fuse tripped Check power source • Motor failure Have motor checked • Loose wire Have motor checked by qualified electrician • Circuit breaker next to on/off switch tripped Allow motor to cool and reset switch

Head Assembly



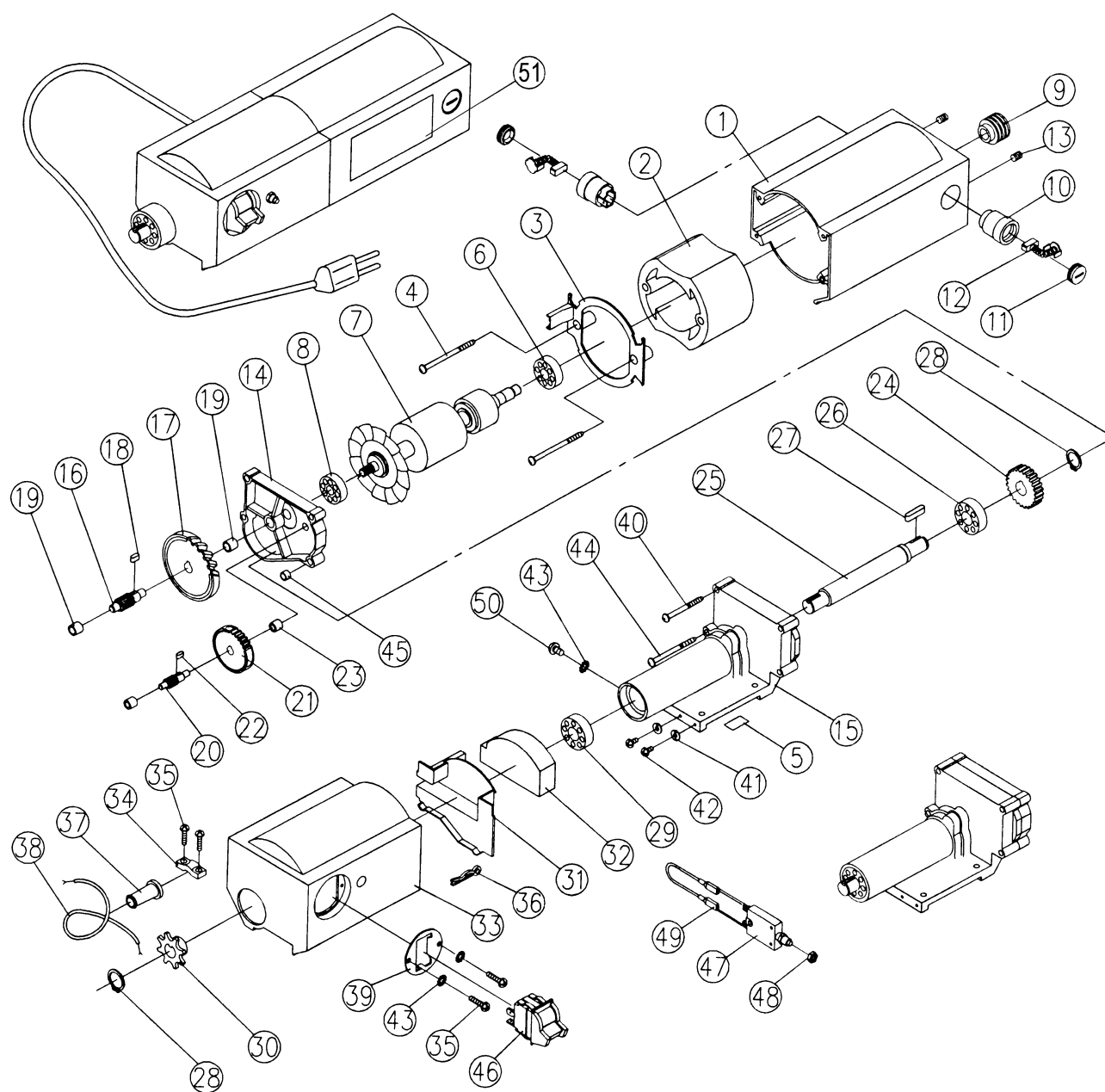
Parts List for the JWP-12DX Planer

Head Assembly

Index No.	Part No.	Description	Size	Qty.
1	PGM-C08	Handle Assembly		1
2	TS-1503041	Hex Socket Cap Screw	M6×16	1
3	TS-1551041	Lock Washer	M6	1
4	PGM-C11	Chain Guard		1
5	TS-1504031	Hex Socket Cap Screw	M8×16	4
6	PGO-C01W	Upper Guard		1
7	PG0501	Chip Guard		1
8	TS-1502071	Hex Socket Cap Screw	M5×30	2
9	TS-1551031	Lock Washer	M5	2
10	JWP12-310	Double Round End Key	5×5×10	1
11	PGM-C12	Cutterhead		1
12	PGM-C05	Roller		2
13	PGM-C07	Bushing		4
14	PGM-C13	Roll Pin		2
15	JEB-C02	Spring		1
16	JWP12-304	Knife Lock Bar		2
17	JWP12-312	Belt		1
18	JWP12-313	Nut		1
19	JWP12-311	Cutterhead Pulley		1
20	JWP12-309	C-Clip		1
21	BB-6203ZZ	Ball Bearing		1
22	JWP12-328	Lock Screw	1/4-28UNF	14
23	708813	Knife		2
24	PG150002	Upper Frame		1
25	TS-1532022	Cross Point Pan Head Screw	M4×8	4
26	TS-1550021	Flat Washer	M4	3
27	JWP12-321	Pulley Guard		1
28	BB-6202ZZ	Ball Bearing		1
29	JWP12-307	C-Clip		1
30	PG010029	Indicator		1
31	5JI-M01	Wire Clip		1
32	JWP12-316	Spring		3
33	JWP12-315	Roller Bracket		4
34	JWP12-317	Bracket Plate		4
35	TS-1533032	Cross Point Pan Head Screw	M5×10	8
36	JWP12-314	Rubber Roller		2
37	JWP12-145	Self Tapping Screw	M6×20	2
38	JWP12-144	Pin		2
39	TS-1551041	Lock Washer	M6	6
40	TS-1503051	Hex Socket Cap Screw	M6×20	2
41	JWP12-319	Spacing Collar		1
42	JWP12-132	Sprocket		3
43	JWP12-148	Chain		2
44	TS-153302	Cross Point Pan Head Screw	M5×10	2
45	PG030009	Pin		2
46	PG010034	Spring		1
47	HB210810	Hex Socket Cap Screw	1/4"×20NC×1"	2
48	HE011600	Flat Washer		2
49	PG060008	Stop Plate		4
50	HF011300	C-Clip	STW-15	2
51	PG1501	Indicator Assembly		1
52	HA260100	Cross Point Pan Head Screw	M4×0.7P×8	2
53	HG050606	Split Pin	2×12L	2

Index No.	Part No.	Description	Size	Qty.
54	PG060010	Handle		2
55	PG010036	Spring		1
.....	PG010048K	Knife Gauge Assembly (not shown)		1
.....	JWP12-AP	Accessory Package		1

Motor Assembly



Motor Assembly

Index No.	Part No.	Description	Size	Qty.
1	JWP12-101	Motor Casing		1
	PGO-M	Motor Assembly		1
2	JWP12-102	Stator Assembly		1
3	JWP12-103	Plate		1
4	JWP12-104	Self-Tapping Screw		2
5	PGA-M28	Motor Label		1
6	BB-6201	Ball Bearing		1
7	JWP12-107	Rotor Assembly		1
8	BB-6200	Bearing		1
9	JWP12-109	Motor Pulley		1
10	JWP12-110	Brush Bracket		2
11	JWP12-112	Brush Cover		2
12	JWP12-111	Brush		2
13	TS-1523031	Set Screw	M6 x10	2
14	JWP12-114	Gear Box Cover		1
15	JWP12-115	Gear Box		1
16	JWP12-116	Pinion		1
17	JWP12-117	Gear	70T	1
18	JWP12-118	Double Round End Key	4 x 4 x 8	1
19	JWP12-119	Bronze Bushing		2
20	JWP12-121	Pinion		1
21	JWP12-122	Gear	46T	1
22	JWP12-118	Double Round End Key	3 x 3 x 7	1
23	JWP12-124	Bushing		2
24	JWP12-126	Gear	33T	1
25	JWP12-127	Shaft		1
26	BB-6202Z	Ball Bearing		1
27	JWP12-129	Double Round End Key	4 x 4 x 10	1
28	JWP12-130	C-Clip		2
29	BB-6002Z	Ball Bearing		1
30	JWP12-132	Chain Sprocket		1
31	JWP12-133	Cover		1
32	JWP12-138	Dust Guard Plug		1
33	JWP12-134	Switch Box		1
34	JWP12-141	Electrical Wire Clamp		1
35	JWP12-142	Self Tapping Screw	M4 x 16	4
36	JWP12-154	R-Type Pin		3
37	JWP12-140	Cord Guide		1
38	JWP12-139	Power Cord		1
39	JWP12-137	Switch Plate		1
40	JWP12-143	Self Tapping Screw	M4.85 x 50	3
41	TS-1550021	Flat Washer	M4	2
42	TS-1532032	Cross Point Pan Head Screw	M4 x 8	2
43	JWP12-150	Tooth Washer		3
44	JWP12-151	Self Tapping Screw	M4.85 x 60	1
45	JWP12-153	Positioning Pin		2
46	JWP12-135	On-Off Switch		1
	KEY-2	Switch Key		1
47	PGA-M22A	Thermal Reset Switch		1
48	PGA-M22C	Nut		1
49	PGA-M23	Temperature Control Wire		1
50	5AD-D04A	Screw	M5 x 8	1
51	PGA-M22B	Name Plate		1
	PGM-L02	Warning Label (not shown)		1
	PGA-M24N	I.D. Label (not shown)		1

Table Assembly

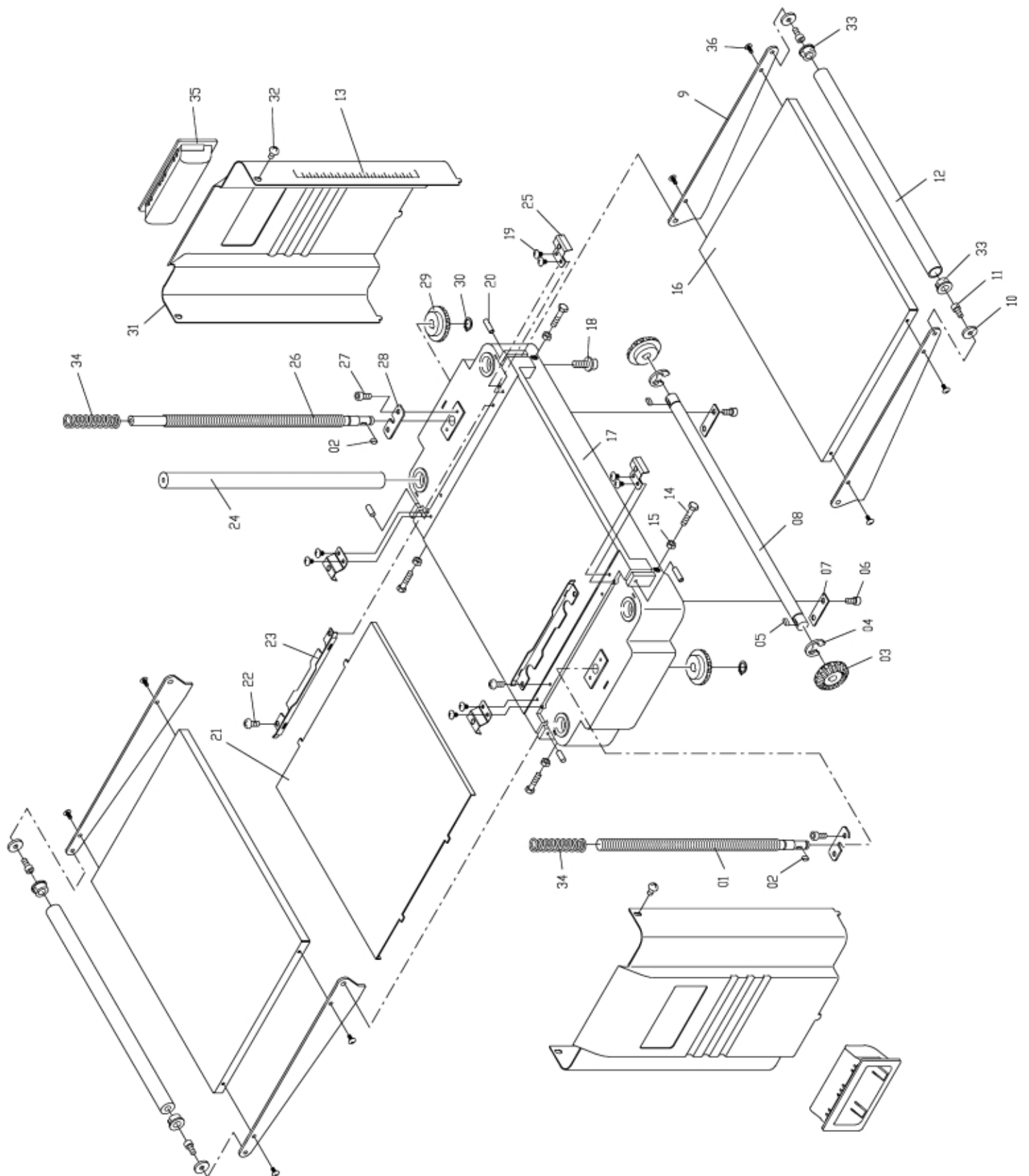


Table Assembly

Index No.	Part No.	Description	Size	Qty.
1	PGM-B01	Leadscrew (left)		1
2	JWP12-123	Double Round End Key	4×4×8	2
3	PGM-B02	Bevel Gear		2
4	5FC-A03	E-Clip		2
5	JWP12-123	Double Round End Key	4×4×8	2
6	TS-1502021	Hex Socket Cap Screw	M5×10	4
7	MGA-C31	Bracket		2
8	PGM-B03	Transmission Shaft		1
9	PG060002	Table Extension Bracket		4
10	TS-1550041	Flat Washer	M6	4
11	TS-1523021	Hex Socket Cap Screw	M6×8	4
12	PGM-B12	Table Extension Roller		2
13	JWP12-325	Depth Scale		1
14	TS-1482051	Hex Cap Bolt	M6×25	4
15	TS-1504041	Hex Nut	M6	4
16	PG150001	Extension Table		2
	PG150001A	Extension Table Assembly		
17	PG021001	Bed		1
18	HA280100	Hex Socket Cap Screw/Washer	M8×P1.25×20	4
19	HA180303	Cross Point Pan Head Screw	M4×1.59	8
20	5FF-L18	Spring Pin	6×20	4
21	PGM-B05	Pad		1
22	TS-1534032	Cross Point Pan Head Screw	M6×10	4
23	JWP12-206	Guide Plate		2
24	PGM-B06	Column		4
25	PG010019	Spring Plate		4
26	PGM-B07	Leadscrew (right)		1
27	TS-1503021	Hex Socket Cap Screw	M6×10	4
28	MGA-B09	Plate		2
29	PGM-B02	Bevel Gear		2
30	5FA-A05	C-Clip		2
31	PGO-B02W	Side Guard		2
32	5AD-D03A	Cross Point Pan Head Screw	M5×6	4
33	PGM-C06	Bushing		4
34	JWP12-211	Spring		2
35	PGO-B03	Handle		2
36	TS-1532032	Cross Point Pan Head Screw	M4×8	8